

Date: Thursday, 21/05/2009 11:21:57 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: RIB	
Job Number	: 48101		Part Number	: D22211	
Estimate Number	: 13673		Drawing Number	: D2221 REV H (PG.5)	
P.O. Number	:		Project Number	: N/A	
This Issue	: 21/05/2009 S.O. No. :		Drawing Revision	: H	
Prsht Rev.	: NC		Material	:	
First Issue	: / / Type : LARGE FAB ASSY		Due Date	: 27/05/2009 Qty: 8 Um: Each	
Previous Run	: 47952				
Written By	:				
Checked & Approved By	: JUL 09.05.21				
Comment	: Est Rev:A New Issue 08-12-02 DD verified by:EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W Scrap End bar $3.5 \times 8 = 28 \times .12 = 2.33\text{sf}$
		Comment: Qty.: 8.4000 f(s)/Unit Total: 67.2000 f(s) 304 SQ Tube .75x.75x.065W batch: M111885
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
		Comment: LARGE FABRICATION RESOURCE 1 1- Cut as per dwg D2221 2- Deburr and remove identification markings on tube
3.0	QC5	INSPECT WORK TO CURRENT STEP
		Comment: INSPECT WORK TO CURRENT STEP
4.0	PACKAGING 1	PACKAGING RESOURCE #1
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: UVA
5.0	QC21	FINAL INSPECTION/W/O RELEASE
		Comment: FINAL INSPECTION/W/O RELEASE
Job Completion		MF 07-06-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

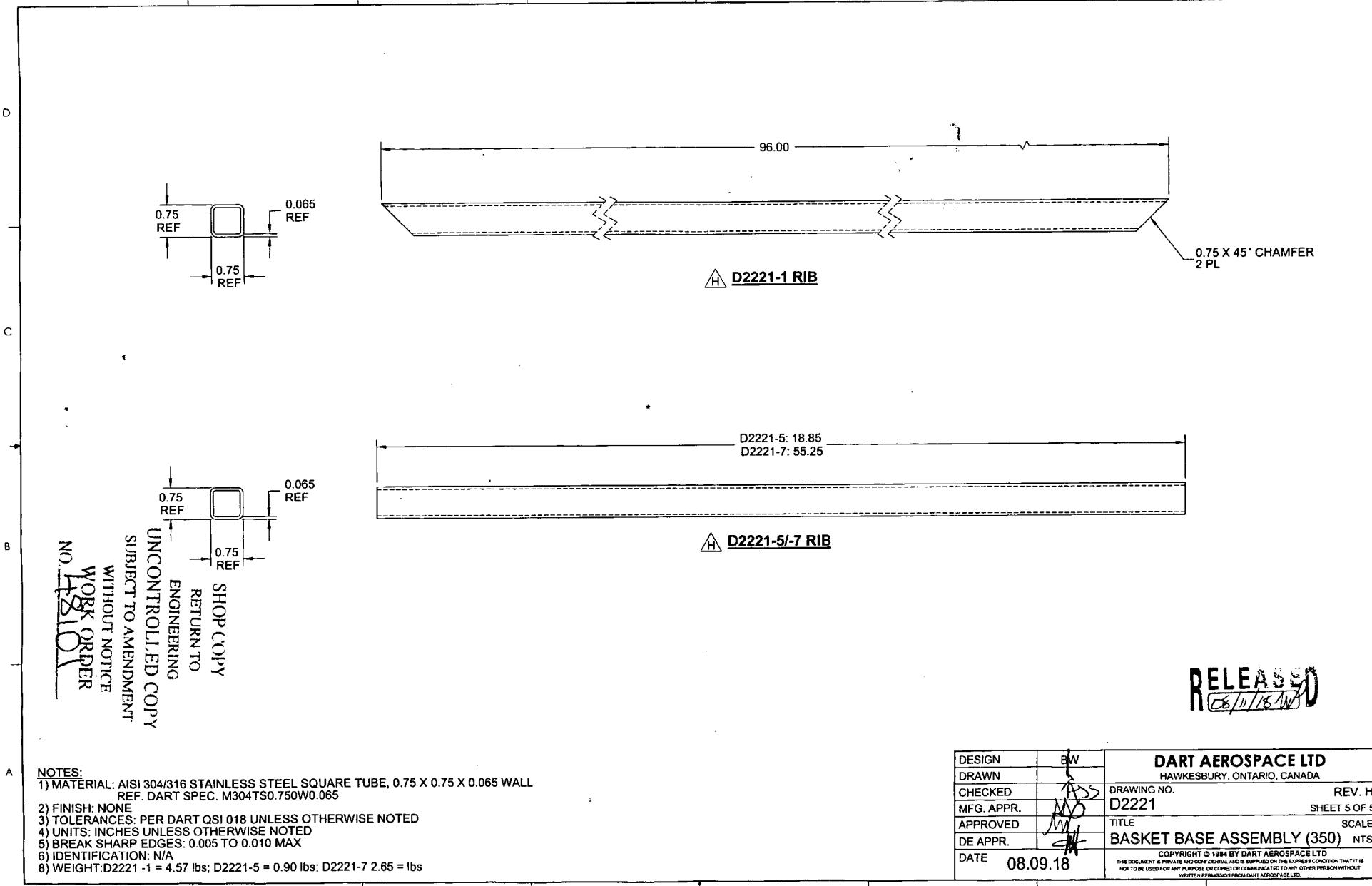
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



NOTES:
 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
 REF. DART SPEC. M304TS0.750W0.065
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 8) WEIGHT:D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED	<i>AS</i>	
MFG. APPR.	<i>NO</i>	
APPROVED	<i>WV</i>	
DE APPR.	<i>WV</i>	
DATE	08.09.18	
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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